

Work Order ID 54717

December 16, 2009 4:15:08 PM



Page 2

Item ID: D3290-041

Accept



Setup Start



Revision ID:

Item Name: Replacement Window Assembly

Stop



Start Date: 12/16/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 12/18/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

BR 09-12-17

(8)

Memo

0.00

Hand Finishing

140



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

BR 09-12-17

(8)

Memo

START TIME: 10:46
OVEN TEMPERATURE: 320°
FINISH TIME: 11:10

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

= 241 09-12-17

(28)

Memo

0.00

Work Order ID 54717

December 16, 2009 4:15:08 PM

Page 3

ASAP 66

Item ID: D3290-041

Accept

Setup Start

Revision ID:

Item Name: Replacement Window Assembly

Stop

Start Date: 12/16/2009 Start Qty: 8.00

Cust Item ID:

Required Date: 12/18/2009 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Small Fab	Small Fab	0.00				8			
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3290 Clean D3290-041 and place in plastic wrap								
170 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
180 Packaging	Identify as per dwg & Stock Location: 215	0.00							
Packaging	Memo	0.00							

SAD
09-12-30

⇒ 8 10/01/04

28

12/16/09

Work Order ID 54717

December 16, 2009 4:15:08 PM



Page 4

Item ID: D3290-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Window Assembly

Start Date: 12/16/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 12/18/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-01-05

Bl 10-1-04

(4)

Picklist Print

December 16, 2009 4:15:07 PM

Page 1 / 1

Work Order ID: 54717

Parent Item: D3290-041

Parent Item Name: Replacement Window Assembly

Start Date: 12/16/2009

Required Date: 12/18/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

100

sf

97.7377

31.5789



6061-T6 .063 Sheet

B9-12-7

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

97.73772105

110551

29.6341211

12939

68.1036

D2126

Manufactured

No

160

f

309.3334

52.0000



Seal

112939

SAD 09-12-30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

309.3334

48285

309.3334

(D2126-0780) cut qty (1) at 78.00" as per dwg
per kit

D3290-3

Manufactured

No

160

Each

3.0000

8.0000



Window

52,000

SAD 09-12-30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

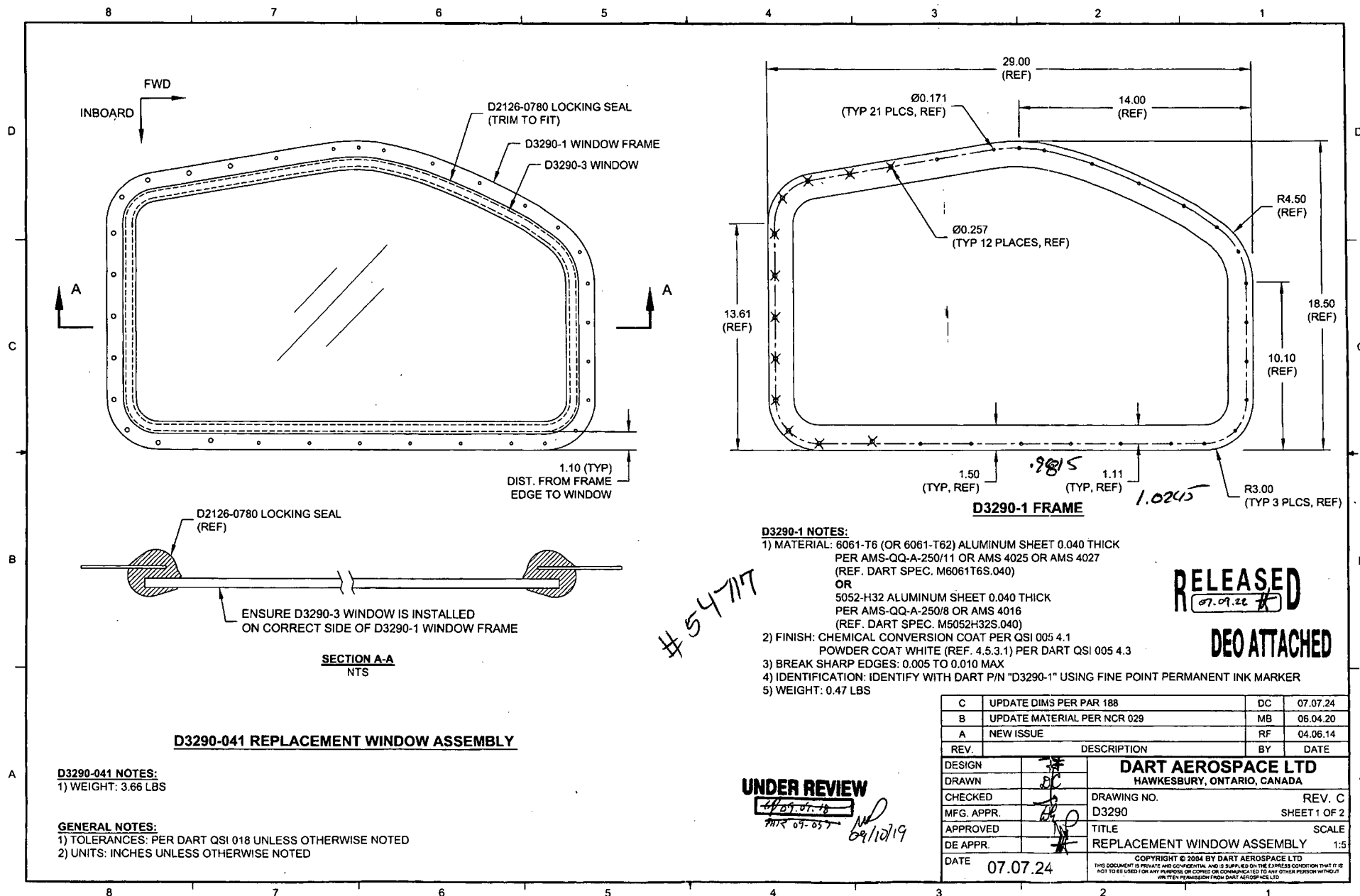
3

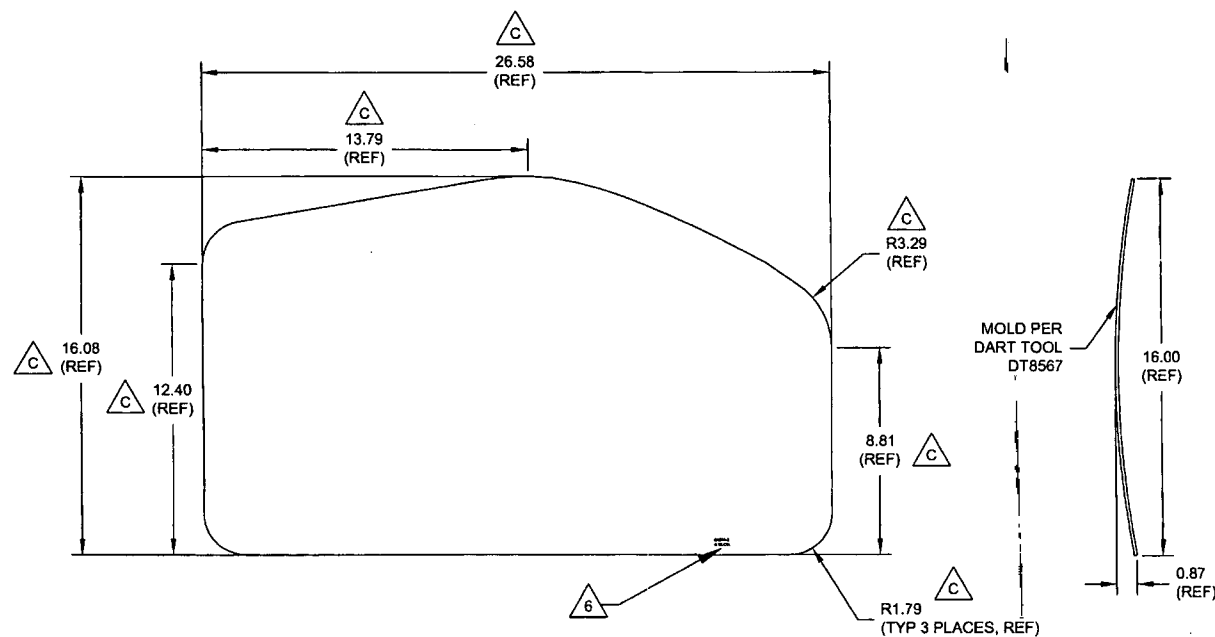
47693

3

B53897

8





D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3290	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY	1:5
DATE	07.07.24	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

UNDER REVIEW

**DEO ATTACHED
RELEASED**
07.09.22

#54717

DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 90	CHECKED 15	MFG. APPR. E	APPROVED MD		DE APPR. #		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21		DATE 09/09/21		

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

#54717

RELEASED
 2009 -10- 09

COPYRIGHT © 2009 BY DART AEROSPACE LTD
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
 NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
 WRITTEN PERMISSION FROM DART AEROSPACE LTD.

